

Work Order ID 61877

Wednesday, September 08, 2010 2:44:26 PM



Page 1

Item ID:	D2330-7	Accept		Setup	Start	
Revision ID:						
Item Name:	Frame				Stop	
Start Date:	9/8/2010	Start Qty: 2.00		Cust Item ID:		
Required Date:	9/13/2010	Req'd Qty: 2.00		Customer:		

Reference:

Approvals:	Process Plan:		Date:	10-9-08	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr

100		0.00							
Large Fab	Memo	0.00							
Large Fab	1- Cut tube as per dwg D2330 2- remove identification marks and deburr								

SY 10/09/08 (2x)

110	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

8/10/09/08

(+2)

120	Identify as per dwg & Stock Location:	0.00							
Packaging	Basket cell	0.00							
Packaging	Memo								

SY 10/09/08 (2x)

Work Order ID 61877

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Item ID: D2330-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Frame

Start Date: 9/8/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/09

MF

10-9-08

Picklist Print

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Page 1

Work Order ID: 61877



Parent Item: D2330-7



Parent Item Name: Frame


Start Date: 9/8/2010

Required Date: 9/13/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.09.08 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.065 		Purchased	No			100	f	1,161.595	2.12	4,463.158			
304 SQ Tube .75x.75x.065W													

MS 10/09/08 (2x)

Location

Loc Qty

Loc Code

MAT

1118.3049

112398

0

114482

1.4628

115494

536.8421

115593

580

WA

43.290385

114520

11.363385

115274

31.927

2.23

2.23

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2330-041	BASKET ASSEMBLY
3		X	D2330-043	LID ASSEMBLY
7	1		D2012-107	CLEVIS
8	4		D2235-1	RIB
9	2	2	D2252-1	FRAME
10	1	4	D2252-7	FRAME
11	2		D2253-1	LUG
12	2		D2254	GUSSET
13	1	1	D2327-3	BUSHING
14		1	D2329	LABEL PLATE
15	2	2	D2330-1	FRAME
16	1		D2330-5	FRAME
17	1		D2330-7	FRAME
18		1	D2330-15	FRAME
19	4	2	D2581	MOUNTING CHANNEL
20	3		D3748-1	HINGE HALF
21		3	D3749-1	HINGE HALF

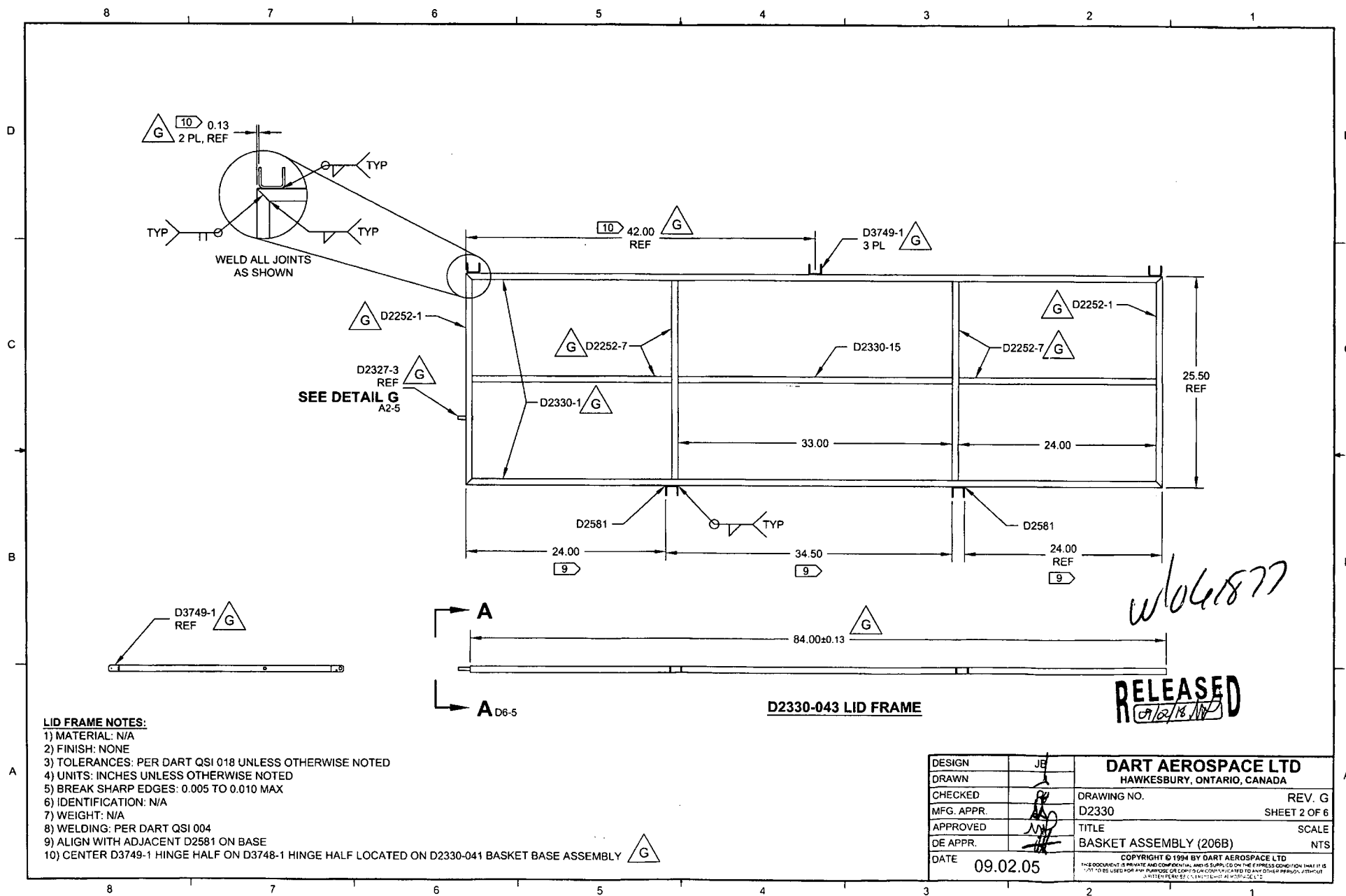
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO:
FOR NOTICE
NO. *CA 877*
010-908

RELEASED
01/2/05 MB

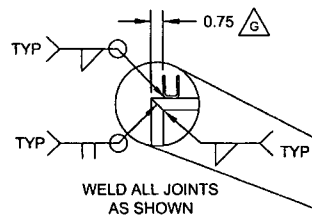
NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

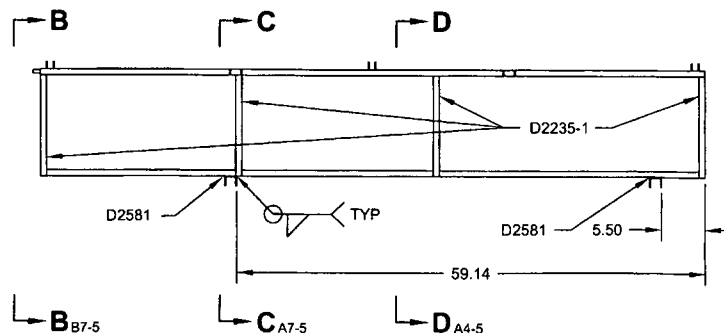
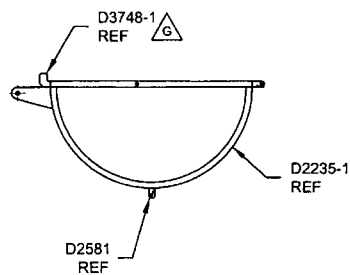
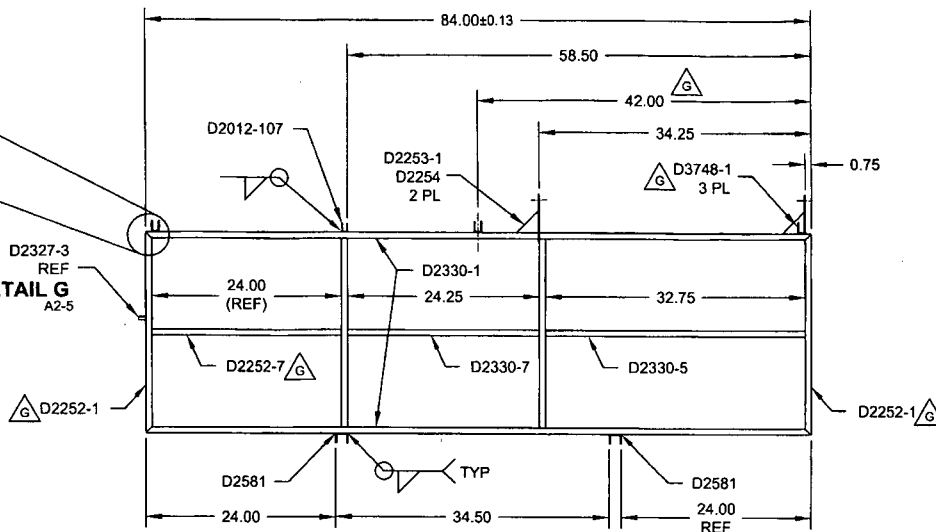
G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 20 AND 21 REPLACE D2232-1/-3; STRETCHED LID FROM 83.27" TO 84.00"; ITEMS 9 & 10 REPLACE D2330-3/-9/-13; ITEM 13 (ON LID) REPLACES D2327-1; REORGANIZED ALL SECTION & DETAIL VIEWS. REASON: SEE PAR#09-006.	MB	09.02.05
F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.080.	AJS	08.08.11
E	INCORPORATED D1. D2253-1 WAS D2253 (NCR 533).	KE	05.11.10
D	MODIFIED LATCH, REDRAWN	KE	99.09.14
C	ADDED LATCH AND LABEL PLATE	BK	96.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JIB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JIB		
CHECKED	JIB		
MFG. APPR.	JIB		
APPROVED	JIB		
DE APPR.	JIB	DRAWING NO. D2330 REV. G SHEET 1 OF 6 TITLE BASKET ASSEMBLY (206B) SCALE NTS	
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8 7 6 5 4 3 2 1



SEE DETAIL G
A2-5



D2330-041 BASE FRAME ASSEMBLY

BASE FRAME NOTES:

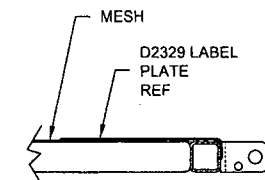
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

DESIGN	JB	DART AEROSPACE LTD	
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CHECKED		DRAWING NO. D2330	REV. G SHEET 3 OF 6
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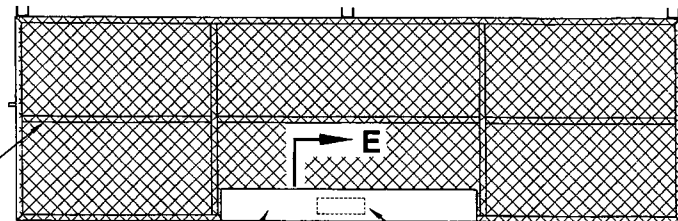
8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

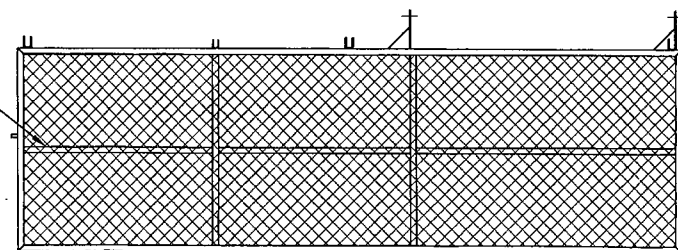


SECTION E-E
VIEW ROTATED 90° CCW

TACK WELD EACH
STRAND END OF
MESH TO FRAME

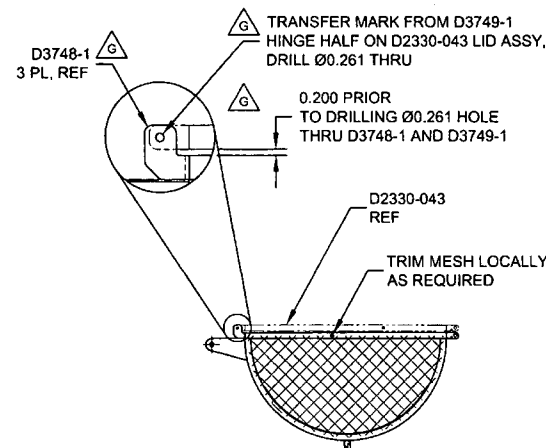


D2330-043 LID ASSEMBLY



D2330-041 BASE ASSEMBLY

w/b 61877



ASSEMBLY NOTES:

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

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MFG. APPR.		D2330	SHEET 4 OF 6
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

C

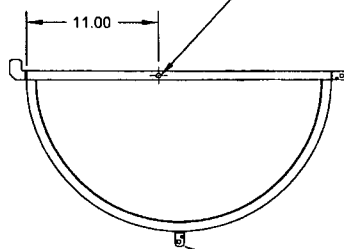
B

A



VIEW A-A A6-2

DRILL 3/8 HOLE AND
INSTALL D2327-3
SEE DETAIL G A2-5



VIEW B-B A5-3

D2581
REF

D2012-107
REF

D2581
REF

D2253-1
REF

EXPANDED
METAL

WELD D2581
WITH LARGE HOLE
ON THIS SIDE

SECTION C-C A4-3

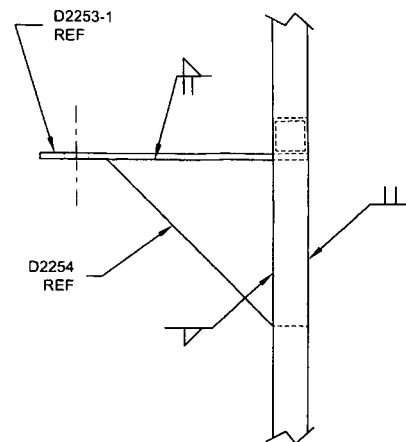
C2-5
F

F

D2253-1
REF

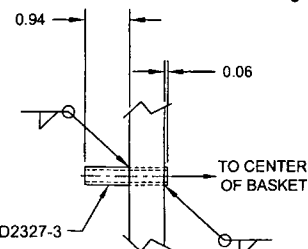
EXPANDED
METAL

SECTION D-D A3-3



VIEW F-F B6-5
SCALE 4X

u b l 877



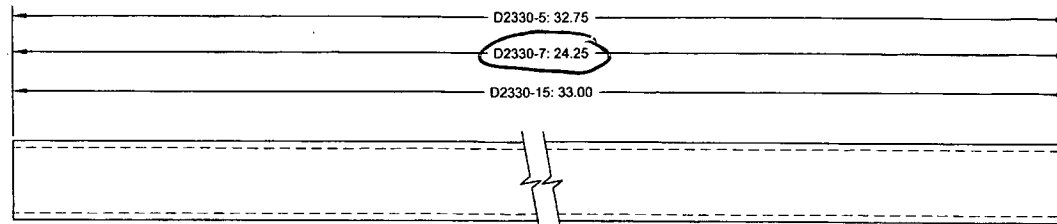
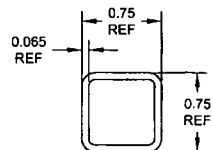
DETAIL G
SPACER INSTALLATION
SCALE 4X

C6-2
C5-3
C6-5

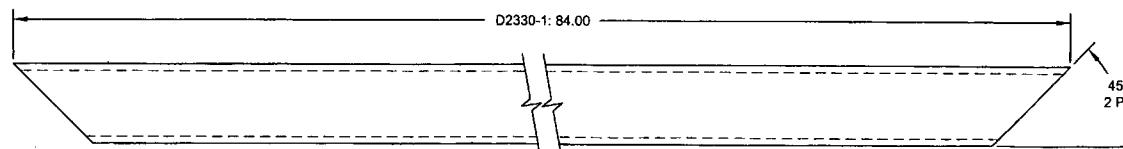
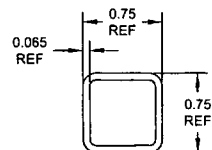
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MFG. APPR.		D2330	SHEET 5 OF 6
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8 7 6 5 4 3 2 1



D2330-5 FRAME
D2330-7 FRAME
D2330-15 FRAME



D2330-1 FRAME

u/b 41877

RELEASED
9/2/18

NOTES:

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

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